

**WHAT IS CLAIMED IS:**

- Sub  
a2*

  1. A method of milling a material comprising:
    2. providing a silicon nitride based cutting tool insert;
    3. cutting at a cutting speed of 1000-3000 m/min; and
    4. feeding at a feeding rate of 0.05-0.5 mm/tooth to a cutting depth of 0.2-2 mm,
    5. *per spec. p. 12 - 13, not 1 mm all -  
is ab. w/ cast iron liners*
    6. wherein the material comprises aluminum and cast iron.*and clear  
without this means  
exact*
  2. The method of claim 1, wherein the cutting tool insert has a chip thickness of 0.09-0.17 mm.

add a3